



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D206-642-212
Job Sheet 188613



Part No: D206-642-212

Job Qty: 1 pcs

Part Name: Skidtube RH, High Gear with Standard Wearplates (2.5" Bolt Spacing on Aft Saddle)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/19

Job Tracking No:

Due Date: 2/22/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV Q SHEET 27 IPP Rev:K 05.07.14 ECN 847 & 901; Add Tow Ring and GHW Kit KJ/CP/JLM IPP Rev:L 07-12-04 ECN 1080p DD verified by: IPP rev M 10.02.02 per IIN rev M EC verified by: JLM IPP REV:N 11.11.17 PER IIN REVO DD VERF; EC IPP Rev:O 12.11.21 ECN12-679 DD verf:JLM IPP Rev:P 14.04.24 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	2/22/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		MAR 04 2019
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							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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www.dartaerospace.com

Container No: S158726



Part: D206-642-212

Job No: 188613

Serial No/Batch: S158726

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, TC SH98-

					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	2/22/19	0.00 0.00		QC 4 - 26	
					QC 4 - 28	
					QC 4 - 38	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
130 Packaging 3-1 - Stock - B4B	1 pcs	2/22/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	2/22/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
140 QC 21 - FG	1 pcs	2/22/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
Part Op 110 - Packaging1-2 (Pick Kit)						
Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness)						
130 - Packaging3-1 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D206-642-						

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212 Location : FG083

135 - DC (Document Control) Photocopy bluefile & type labels per PPP206-642-212 CHG008

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5133784
AN4-6A	Bolt	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5074205
AN4C5A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5057496
AN5-11A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5003927
AN5-7A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	51123355
AN6-44A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5123265X1 5123265-1X1
D206-642-241	Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5141123 *
D206-651-041	206 A/B Ground Handling Wheel	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5134599
D2652	Bushing	16 pcs (16 ea)	110-Packaging 1 - Pick Kit	5136093
D2665-2	Saddle, RH, Fwd, Aft, Out	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5157200
D2666-2	Saddle, RH, Fwd, Aft, In	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5072113
D2712	Set Screw	10 pcs (10 ea)	110-Packaging 1 - Pick Kit	5059551
D2884	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5101436
D2885	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5054580
D3413-1	O-Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5114083
MS21042L3	Nut	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5132364
MS21042L4	Nut	12 Ea (12 ea)	110-Packaging 1 - Pick Kit	5149814
MS21042L6	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5107756
NAS1149C0463R	Washer	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5124667
NAS1149D0363J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5123436
NAS1149D0463J	Washer	24 Ea (24 ea)	110-Packaging 1 - Pick Kit	5150216
NAS1149D0563J	Washer	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5123450
NAS1149D0663J	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5093765

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-41A	8	119	0
	AN4-6A	12	625	0
	AN4C5A	1	43	0
	AN5-11A	4	211	0
	AN5-7A	4	3,200	0
	AN6-44A	2	115	0
	D206-642-241	1	4	0
	D206-651-041	1	4	0
	D2652	16	546	0
	D2665-2	2	1	0
	D2666-2	2	4	0
	D2712	10	581	0
	D2884	2	40	0
	D2885	2	24	0
	D3413-1	1	37	0
	MS21042L3	8	1,850	0
	MS21042L4	12	1,575	0
	MS21042L6	2	352	0
	NAS1149C0463R	1	437	0
	NAS1149D0363J	8	971	0
	NAS1149D0463J	24	2,677	0
	NAS1149D0563J	8	1,019	0
	NAS1149D0663J	4	1,012	0
Part Specifications				
Specifications could not be found.				

Plex 1/30/19 8:15 AM Dart.Hadley.Shannon



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D206-642-212
Job Sheet 188613



Part No: D206-642-212

Job Qty: 1 ea

Part Name: Skidtube RH, High Gear with Standard Wearplates (2.5" Bolt Spacing on Aft Saddle)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/11/19

Job Tracking No:

Due Date: 2/22/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV Q SHEET 27 IPP Rev:K 05.07.14 ECN 847 & 901; Add Tow Ring and GHW Kit KJ/CP/JLM IPP Rev:L 07-12-04 ECN 1080p DD verified by: IPP rev M 10.02.02 per IIN rev M EC verified by: JLM IPP REV:N 11.11.17 PER IIN REVO DD VERF; EC IPP Rev:O 12.11.21 ECN12-679 DD verf:JLM IPP Rev:P 14.04.24 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/22/19	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs		2/22/19	0.00	0.00	Packaging1-2		
120	QC	1 pcs		2/22/19	0.00	0.00	QC4		
130	Packaging	1 pcs		2/22/19	0.00	0.00	Packaging3-1		
135	DC	1 pcs		2/22/19	0.00	0.00	DC		
140	QC21-FG	1 Ea		2/22/19	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP D206-642-212 Location : FG083

Descriptions: 135 - Photocopy bluefile & type labels per PPP206-642-212 CHG008

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	
AN5-11A	Bolt	4 Ea (4 ea)	90-Start up Operation	
AN5-7A	Bolt	4 Ea (4 ea)	90-Start up Operation	
AN6-44A	Bolt	2 Ea (2 ea)	90-Start up Operation	
D206-651-041	206 A/B Ground Handling Wheel	1 pcs (1 ea)	90-Start up Operation	
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	
D2665-2	Saddle, RH, Fwd, Aft, Out	2 Ea (2 ea)	90-Start up Operation	
D2666-2	Saddle, RH, Fwd, Aft, In	2 pcs (2 ea)	90-Start up Operation	
D2712	Set Screw	10 pcs (10 ea)	90-Start up Operation	
D2884	Saddle Spacer	2 pcs (2 ea)	90-Start up Operation	
D2885	Saddle Spacer	2 pcs (2 ea)	90-Start up Operation	
D3413-1	O-Ring	1 pcs (1 ea)	90-Start up Operation	
MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation	
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	
MS21042L6	Nut	2 Ea (2 ea)	90-Start up Operation	
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation	
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation	
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation	
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation	
NAS1149D0663J	Washer	4 Ea (4 ea)	90-Start up Operation	
D206-642-241	Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH	1 Ea (1 ea)	110-Packaging	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabelled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	127	0
	AN4-6A	12	647	0
	AN4C5A	1	44	0
	AN5-11A	4	18	0
	AN5-7A	4	3,200	0
	AN6-44A	2	115	0
	D206-651-041	1	4	0
	D2652	16	378	0
	D2665-2	2	1	0
	D2666-2	2	4	0
	D2712	10	603	0
	D2884	2	40	0
	D2885	2	24	0
	D3413-1	1	45	0
	MS21042L3	8	2,349	0
	MS21042L4	12	1,978	0
	MS21042L6	2	322	0
	NAS1149C0463R	1	453	0
	NAS1149D0363J	8	1,764	0
	NAS1149D0463J	24	2,925	0
	NAS1149D0563J	8	1,164	0
	NAS1149D0663J	4	1,174	0
	D206-642-241	1	4	0
110-Packaging				

Part Specifications

Specifications could not be found.

Plex 1/11/19 2:11 PM dart.white.jesse

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Change Record

PAGE 1 OF 1

Part Number: D206-642-211/-212

Description: SKIDTUBE , LH/RH

[illegible]